Dart Aerospace Ltd.

Date: Wednesday, 3/14/2007 12:25:44 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: WEARPLATE
Job Number	: 31197		
Estimate Number	: 12463		
P.O. Number	: N/A	**Part Number**	: D35085
This Issue	: 3/14/2007 **S.O. No.** : N/A	**Drawing Number**	: D3508 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: B
Previous Run	: 28969	**Material**	: N/A
Written By	:	**Due Date**	: 3/30/2007 **Qty:** 8 **Um:** Each
Checked & Approved By	: 07.03.14		
Comment	: Est Rev:A New Issue 06-06-20 JLM Est Rev:B Now SS as per Rev B 06-12-15 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet

Comment: Qty.: 0.6549 sf(s)/Unit Total : 5.2391 sf(s)
304SS .038" THK (20GA)
(M304S20GA)
Batch: ~~[illegible]~~ M103713 SAO 07/03/18 (8)

Seq. #:	Machine Or Operation:	Description :
2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3508
Dwg Rev: B
Prog Rev: B
07/03/27 (8)
SAO 07/03/18
2-Deburr if necessary (8)

Seq. #:	Machine Or Operation:	Description :
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAO 07/03/18 (8)

Seq. #:	Machine Or Operation:	Description :
4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 07/03/19 (8)

Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
1-Form on brake using DT8326 and DT8261 as per Dwg D3508
SB 07/03/28 (8)

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 07/03/29

QA: N/C Closed: _____ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: WEARPLATE

Job Number: 31197
Part Number: D35085

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07.03.28
7.0	POWDER COATING	POWDER COATING
		M10601
	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	07/03/28 (8)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	07/03/28
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		(8X)
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP	07/03/28
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		(8)
	Comment: FINAL INSPECTION/W/O RELEASE	07/03/29

Job Completion

07-03-29

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

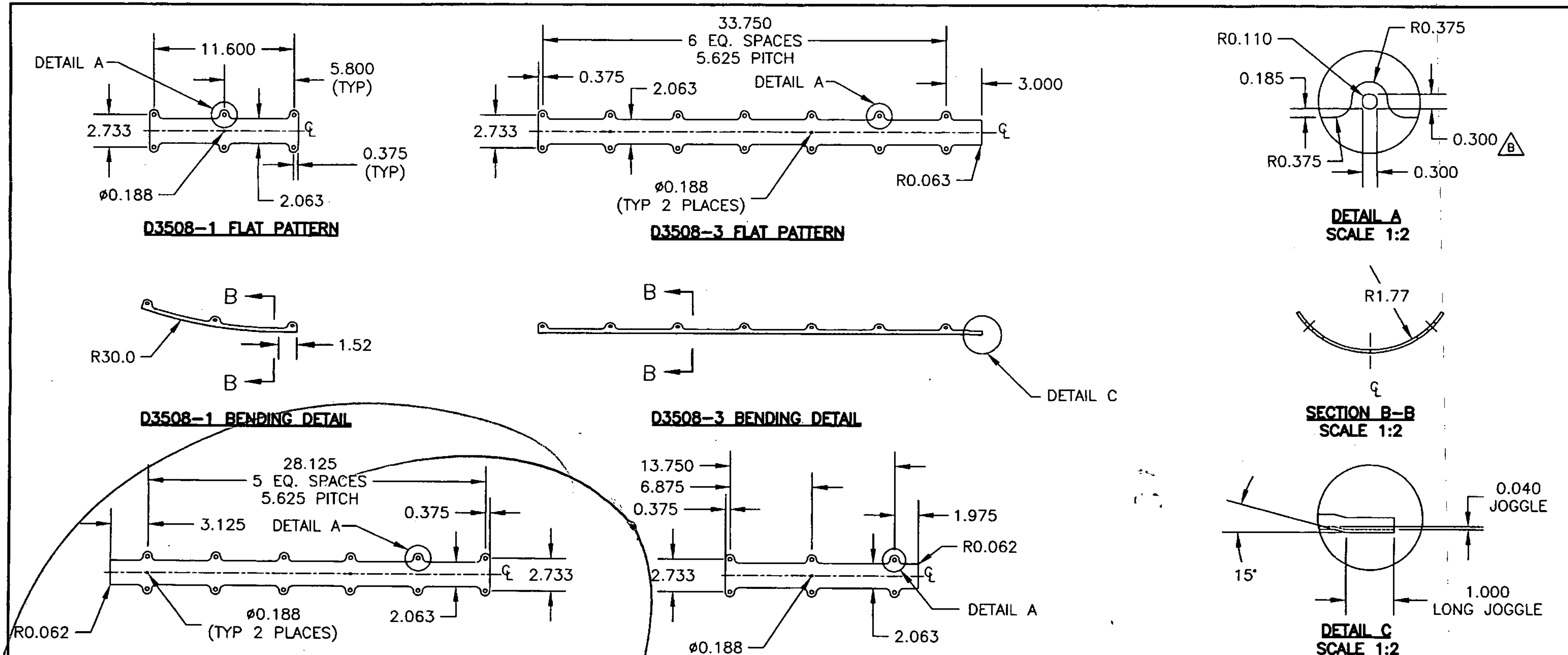
Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

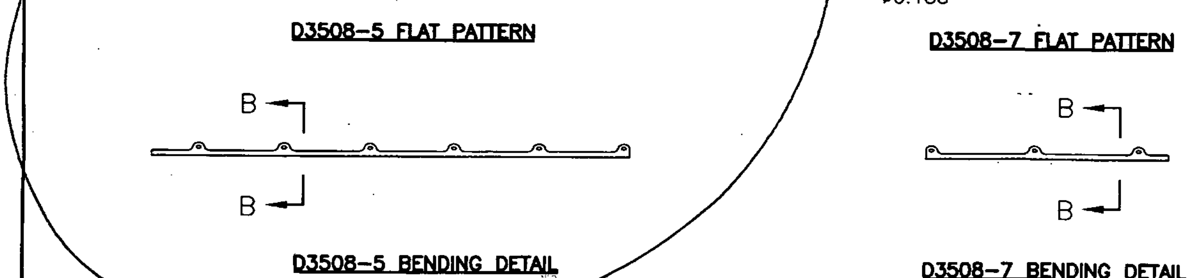
QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD





D3508-1/-3/-5/-7 WEARPLATE NOTES

1) (B) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) PART IS SYMMETRICAL ABOUT CENTERLINE

REV	DATE	DESCRIPTION
B	06.10.27	CHANGE STAINLESS STEEL, WIDEN TAB
A	06.04.21	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	DRAWING NO. D3508 — REV. B — SHEET 1 OF 1
CHECKED	APPROVED	TITLE: WEARPLATE — SCALE 1:8
DATE: 06.10.27		

DART AEROSPACE LTD	Work Order:	31197
Description: Wear Plate	Part Number:	035085
Inspection Dwg: 03508 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.125	+/-0.010	3.124	✓		Vern	
B	2.733	+/-0.010	2.730	✓		Vern	
C	0.375	+/-0.010	0.379	✓		Vern	
D	28.125	+/-0.010	28.125	✓		Vern	
E	5.625 (Pitch)	+/-0.010	5.626	✓		Vern	
F	Ø0.188	+0.005 -0.001	Ø0.190	✓		Vern	
G	2.063	+/-0.010	2.069	✓		Vern	
H	0.300	+/- 0.010	0.303	✓		Vern	
I	0.300	+/- 0.010	0.300	✓		Vern	
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by:	SAD	Audited by:	J.L	Prototype Approval:	N/A
Date:	07/03/18	Date:	07/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	